



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBEM632V1005102

Job Sheet 182204



Part No: RBEM632V1005102

Job Qty: 1 ea

Part Name: Main Gear Box Support Stand



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/20/18

Job Tracking No:

Due Date: 10/29/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: URF 17-704 DWG REV 2 IPP Rev.A 17.08.04 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	1 pcs		10/29/18	0.00	0.00	Purchasing		OCT 22 2018
110	Packaging	1 pcs		10/29/18	0.00	0.00	Packaging2		OCT 22 2018
120	QC	1 pcs		10/29/18	0.00	0.00	QC6		OCT 25 2018
130	Packaging	1 pcs		10/29/18	0.00	0.00	Packaging3-1		OCT 30 2018
140	QC21-SA	1 Ea		10/29/18	0.00	0.00	QC21		OCT 30 2018

Part Op 100 - Issue P/O: 040787 MANUFACTURE RBEM632V1005102 AS PER DWG Supplier: METEC Certificate of Descriptions: conformity is required

aug 20. 2018 x1 R h

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBEM632V1005102P	Maintenance Stand	1 pcs (1 ea)	100-Purchasing	S120290

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBEM632V1005102P	1	0	0

Part Specifications

Specifications could not be found.

Plex 8/20/18 3:05 PM dart.Lussier.Patrick



Container No: S120292



Part: RBEM632V1005102

Job No: 182204

Serial No/Batch: S120292

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 10/22/18



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO040787

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040787
PO Date: 8/20/18
Due Date: 10/29/18
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Revision

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	182203	RBEM632V1005102P			Maintenance Stand receive pcs	Firmed	-	10/29/18	1 Ea	0 Ea	1 Ea	\$10,460.00/Ea	\$10,460.00
Line Item Note Metec already has one in stock built to drawing but without deviation													
2	182204	RBEM632V1005102P			Maintenance Stand receive pcs	Firmed	-	10/29/18	1 Ea	0 Ea	1 Ea	\$10,460.00/Ea	\$10,460.00
Line Item Note Use new deviation for new unit													
3	182209	RBEM621V1006101P			Main Rotor Blade Sling	Firmed	-	10/29/18	1 Ea	0 Ea	1 Ea	\$3,717.20/Ea	\$3,717.20
4	182290	RB T102017P			Main Rotor Hub Sling Assembly	Firmed	-	10/29/18	1 Ea	0 Ea	1 Ea	\$0.01/Ea	\$0.01
5	182845	RB T101753-101P			Combining Gearbox Assembly & Transport Stand	Firmed	-	10/29/18	1 Ea	0 Ea	1 Ea	\$0.01/Ea	\$0.01
6	182845	RBEM621V1006101P			Main Rotor Blade Sling	Firmed	-	10/29/18	1 Ea	0 Ea	1 Ea	\$3,717.20/Ea	\$3,717.20
Grand Total:												\$28,354.42	

Order Notes

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

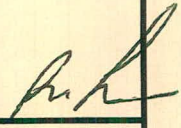
A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS



Plex 9/4/18 4:30 PM dart.Lussier.Patrick

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 24154
Shipment Date: 22-Oct-2018
Ship Via:
Order Number: 1813
Order Date: 08/21/18

Customer Code: DART
Phone: (613) 632-9577
PO Number: PO040787 ✓
Terms: ?

Quantity							
Item	Open	Shipped	B/O	Canceled	Unit	Description	Revision Job Number
1	2	2 ✓	0	0	EA	DART-RBEM632V1005102P Transmission Stand, drawing RBEM632V1005102 Rev.2	1813-01 DAS 68 9-89

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Received In Good Order By

Page 1 of 1



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev.#	P.O. Number
2 ✓	RBEM632V1005102P ✓	Transmission Stand	2	040787 ✓
Deviation attached for Part# RBEM632V1005102-49 /-51				

MATERIAL: supplied by METEC

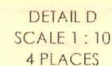
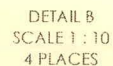
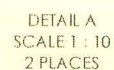
DAS
68
9-89

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


George Theoret

Vankleek Hill, October 22, 2018

[illegible]

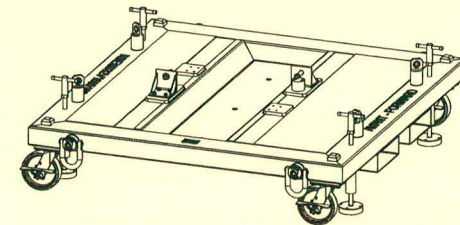
NOTE:
REF. AIRBUS T/N: M632V1005102.

	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102	REV 2
MAT'L HEAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX = .005 FRACTIONS + 1/16 .X = .01 ANGLES ± 5° .XX = .02 SURFACES ± 1/8" ✓
DRAWN BY: CHECKED: Q/PS APPR: DA APPR: APPROVED:	1. BREAK ALL SHARP EDGES .015 ± .45° OR .015H 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL H175
SCALE 1:20	DATE 12/11/2015
SHEET 1 OF 31	

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REVISIONS						
REV	ECN	DESCRIPTION	DATE	INITIAL	APPROVED	
2	16-0182	-83 CHG B/D INFORMATION WAS ADDED & 0.5mm (0.020") B 7/8" UNF (0.250") #10 (HST) ADDED -85 -89 ADDED TO BOM QTY 1. ADDED DRAWING -91 ADDED TO BOM QTY 1. ADDED DRAWING	2/3/2017	SM	JAG	

ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	B/D	Part #	UNIT QTY	Description	Material	B/D INFORMATION OR SPECIFICATIONS	PIC
			X		-1	1	BASE WELDMENT			3
			2		-3		FRONT & REAR TUBE	STEEL		4
			2		-5		SIDE TUBE	STEEL		5
			2		-7		MID TUBE	STEEL		6
			4		-9		ANCHOR POCKET	4140/4142		7
			4		-11		SQUARE LUG	A36/1018/1020 HP		8
			4		-13		JACKSCREW BASE	4140/4142		9
			4		-15		WHEEL PLATE	A36/1018/1020 HP		10
			2		-17		SMALL MOUNT PLATE	A36/1018/1020 HP		11
			2		-19		LARGE MOUNT PLATE	A36/1018/1020 HP		12
			8		-21		FORK POCKET	STEEL		13
			1		-23		BOTTOM PIN	A36/1018/1020 HP		14
			1		-25		SMALL COVER	A36/1018/1020 HP		15
			1		-27		LARGE COVER	A36/1018/1020 HP		16
			4		-29		BE DOWN ANCHOR	4140/4142		17
		X			-31	2	BRACKET WELDMENT			18
		1			-33		BRACKET	A36/1018/1020 HP		19
		2			-35		BRACKET GUSSET	A36/1018/1020 HP		20
					-37	2	BUSHING	4140/4142		21
		X			-39	4	ANCHOR ASSEMBLY			22
		1			-41		ANCHOR	4140/4142		23
X					-43	4	JACKSCREW POD WELDMENT			24
1					-45		JACKSCREW ROD	87	M20 X 2.5mm X 500mm (MCMMASTER-CARR #93325A-442) MODIFIED	25
1					-47		JACKSCREW POD FROOT	4140/4142		26
					-49	4	JACKSCREW COVER	A36/1018/1020 HP		27
					-51	4	JACKSCREW FOOT	4140/4142		28
					-53	2	DELRI RING	WHITE DELRI/ACETAL		29
			B/D		-55	4	JACKSCREW HANDLE	STEEL	M20 X 2.5mm X 5.74 (J.W. WELCO #20H820)	1
			B/D		-57		SPHERICAL BEARING	STEEL	60/80 ID X 01.578 O.D. X .475 (SKF BEG 60/80-085)	22
			B/D		-59	4	CASTER WITH BRAKE	CR	(COLSON) #4.0819-899 (M1028R1)	1
			B/D		-61	16	BUTTON HEAD SOCKET CAP SCREW	SS	M5 X 0.8 X 12mm (MCMMASTER-CARR #9205A210)	1
			B/D		-63	4	SOCKET HEAD CAP SCREW	SS	M6 X 1.25 X 35mm (MCMMASTER-CARR #91270A154)	1
			B/D		-65	8	SOCKET HEAD CAP SCREW	STEEL	M8 X 1.25 X 20mm (MCMMASTER-CARR #90128A174)	1
			B/D		-67	2	SOCKET HEAD CAP SCREW	SS	M16 X 2 X 80mm (MCMMASTER-CARR #91297A247)	1
			B/D		-69	16	HEX HEAD CAP SCREW	STEEL	M14 X 1.5 X 20mm (MCMMASTER-CARR #91190A774)	1
			B/D		-71	8	WASHER	STEEL	M6 (MCMMASTER-CARR #91166A270)	1
			B/D		-73	16	WASHER	STEEL	M14 (MCMMASTER-CARR #91166A300)	1
			B/D		-75	4	WASHER	STEEL	M16 (MCMMASTER-CARR #91166A310)	1
			B/D		-77	4	HEX NUT	STEEL	M16 X 2 (MCMMASTER-CARR #90365A125)	1
			B/D		-79	4	HEX NUT	STEEL	M20 X 2.5mm (MCMMASTER-CARR #90391A280)	1
			B/D		-81	2	HEX NUT	SS	M16 X 2 (MCMMASTER-CARR #91828A430)	1
			B/D		-83	4	BE DOWN	STEEL	7/8" UNF (GROSS) # 10169371	1
			B/D		-85	4	SCREW PLATE	STEEL	#4 X .25 (MCMMASTER-CARR # 90081A144)	1
			B/D		-87	1	GRATE	BRASS GRATE HT	GRATE (60) 16 X 70 X .28	N/S
			B/D		-89	1	LABEL	BLACK CUT VINYL	35X50 INCH	31
			B/D		-91	1	LABEL	BLACK CUT VINYL	35X50 INCH	31
			B/D		-93	1	DART PLACARD	ALUMINUM	KS41011	1

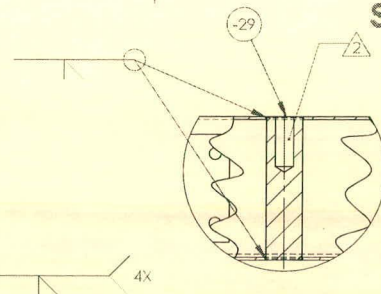
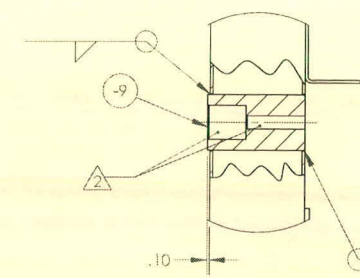
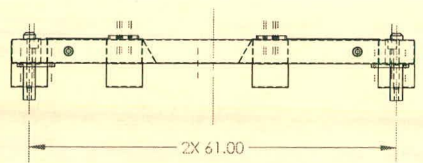
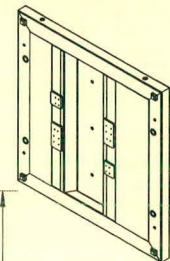
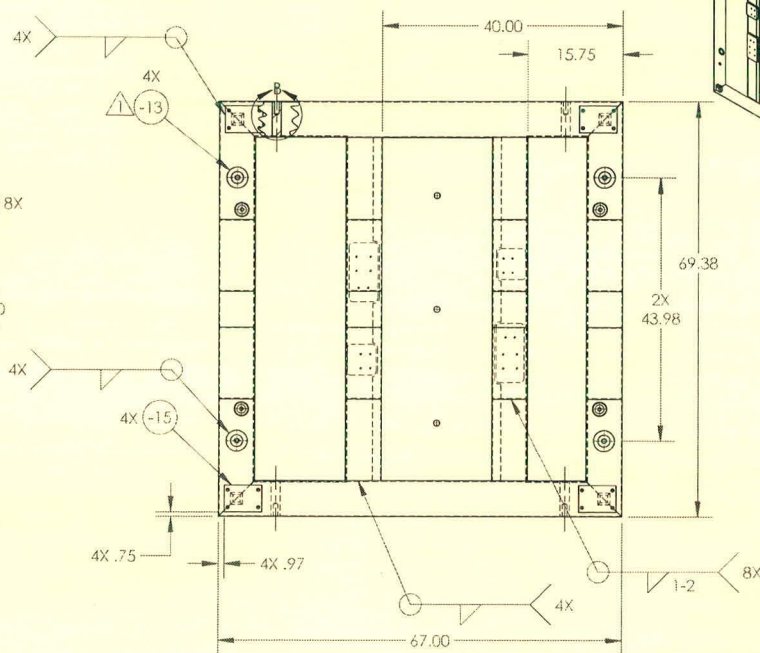
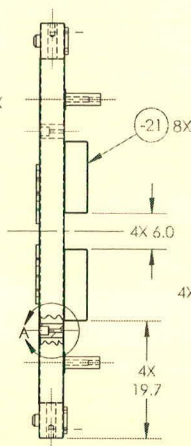
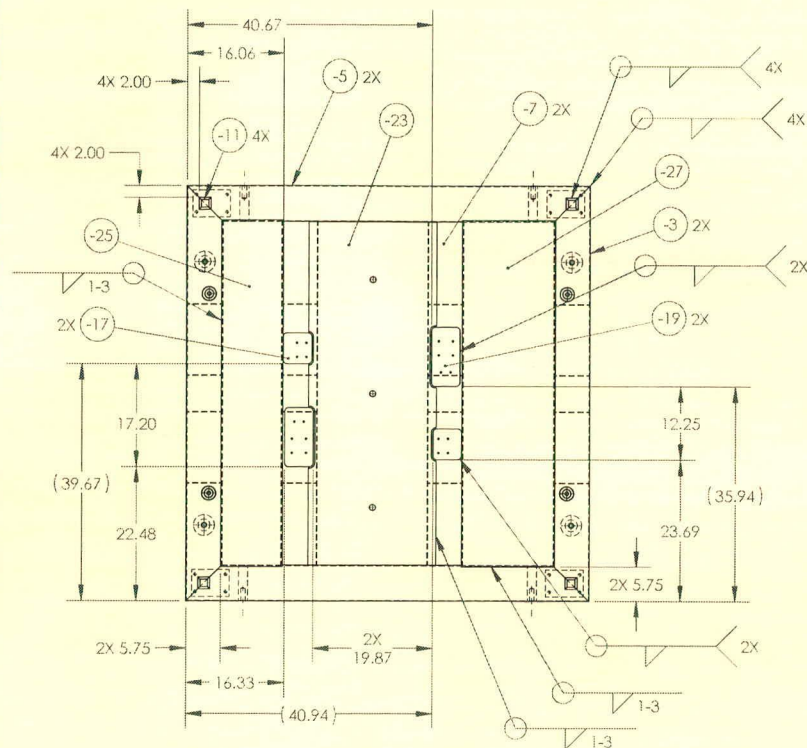


SEE ATTACHED DEVIATION

	
TRANSMISSION STAND	
TITLE	
DWG NO. RBEM632V1005102	
REV 2	
MAT'L: _____	
TREAT: _____	
FINISH: _____	
SPEC: _____	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° X ± .1 SURFACES ± .125	
1. BREAK ALL SHARP EDGES .015 X 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL	
H175	
SCALE 1:24 DATE 12/11/2015 SHEET 2 OF 31	

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REV	ESK	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0182	-1 ADDED DIM 17.25, 2X 19.87, 12.25, 57.00, 69.38, CHG DIM WAS 39.67 IS (39.67) WAS 40.94 D (40.94).	10/26/2016	SM	JAG



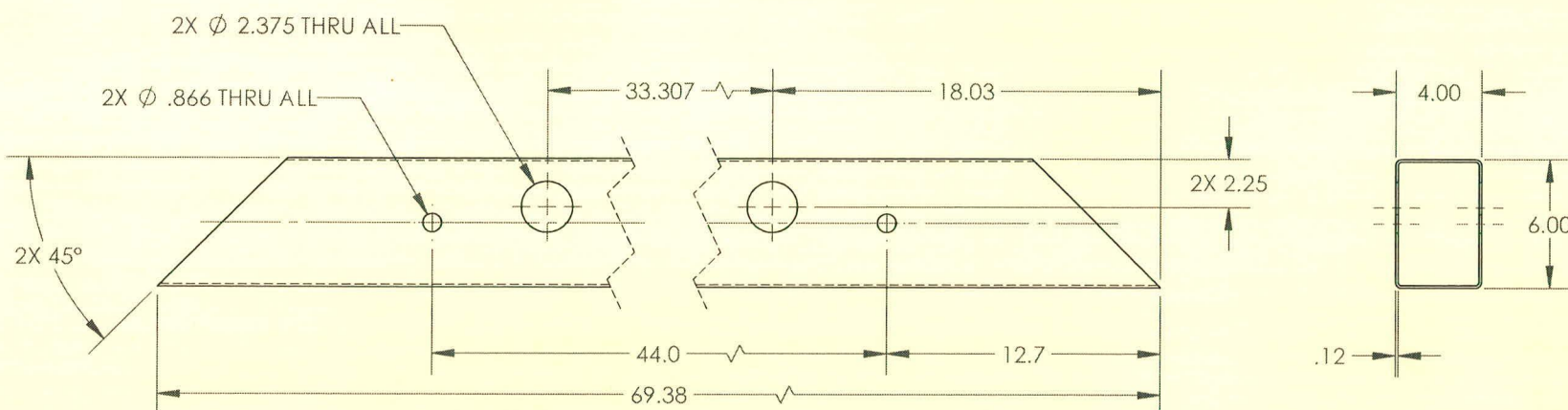
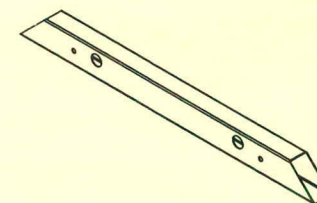
SEE ATTACHED DEVIATION

NOTE:
 1. HOLES MUST ALIGN.
 2. NO POWDER COAT THIS SURFACE.

DART AEROSPACE	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-1	REV 2
MATL. UNLESS OTHERWISE SPECIFIED PART. DIMENSIONS ARE IN INCHES TREAT. .XXX ± .010 FRACTIONS ± 1/8 FINISH. POWDER COAT YELLOW .XX ± .03 ANGLES ± 1° SPEC. FED #13538 X ± .1 SURFACES = 125/✓	
1. BREAK ALL SHARP EDGES .015 ± .05 OR .015H 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: DUERFELDT CHECKED: CLOUGH DESIGNED: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
USED ON MODEL H175	
SCALE 1:20	DATE 12/11/2015
SHEET 3 OF 31	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0182	-3 CH'D DIM WAS .13 IS .12.	10/20/2016	SM	JAG



SEE ATTACHED DEVIATION

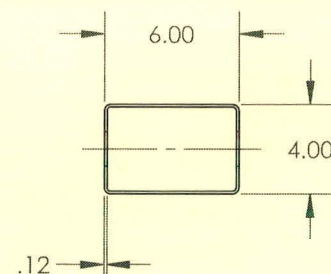
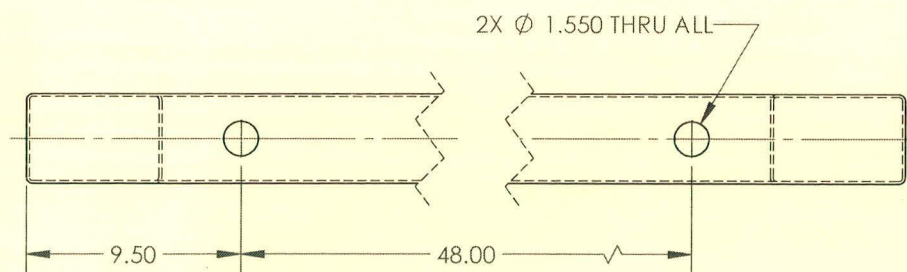
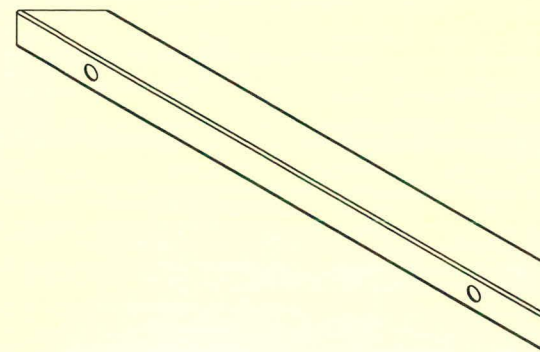
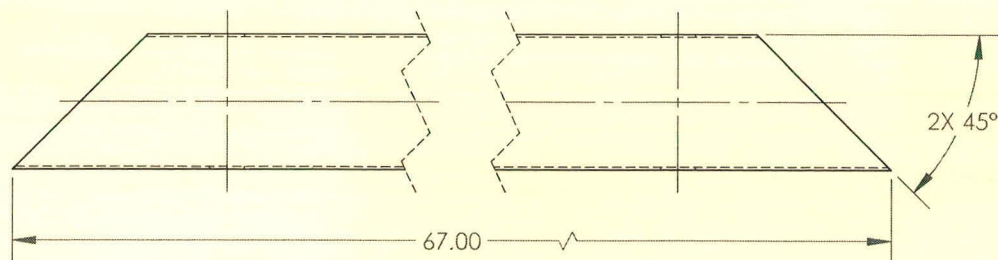
DART AEROSPACE	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-3	REV 2
MAT'L STEEL HEAT TREAT FINISH SEE -1 WELDMENT SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX $\pm$.010 FRACTIONS $\pm$ 1/8 .XX $\pm$.03 ANGLES $\pm$ 1° .X $\pm$.1 SURFACES = 125/ $\sqrt$ 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: DUERFELDT	USED ON MODEL
CHECKED: CLOUGH	H175
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:8	DATE 12/11/2015
SHEET 4 OF 31	

(-3)

FRONT & REAR TUBE

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REVISIONS			DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION			
2	16-0182	-5 CH'D DIM WAS .13 IS .12.	10/20/2016	SM	JAG



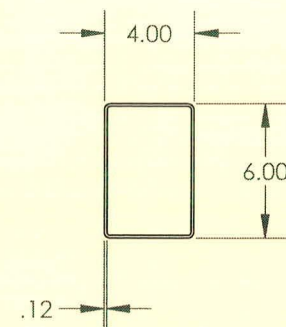
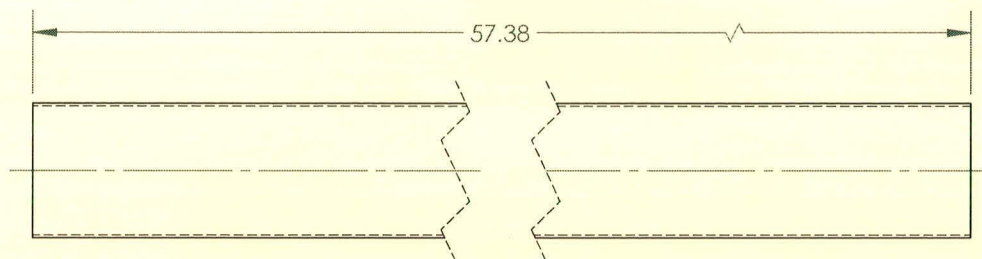
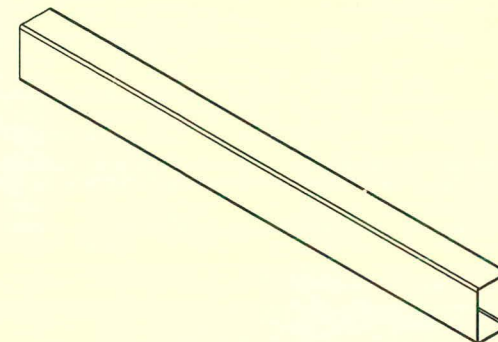
SEE ATTACHED DEVIATION

5
SIDE TUBE

DART AEROSPACE	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-5	REV 2
MAT'L STEEL HEAT TREAT FINISH SEE -1 WELDMENT SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125/	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL	
H175	
SCALE 1:8	DATE 12/11/2015
SHEET 5 OF 31	

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REVISIONS			DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION			
2	16-0182	-7 CHD DIM WAS .13 IS .12.	10/20/2016	SM	JAG



SEE ATTACHED DEVIATION

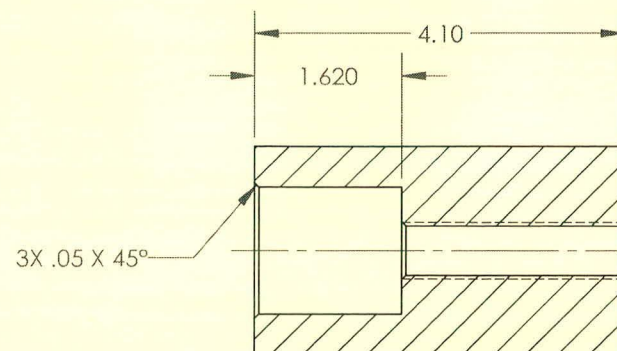
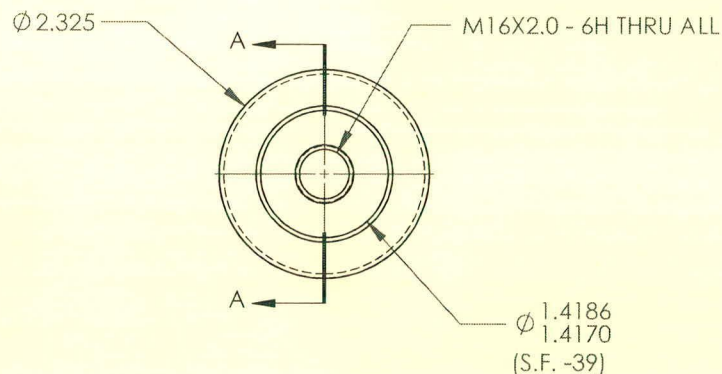
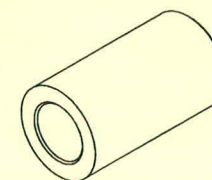
(-7)

MID TUBE

DART AEROSPACE	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-7	REV 2
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH SEE -1 WELDMENT	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125/
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:8	DATE 12/11/2015 SHEET 6 OF 31

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED



SECTION A-A

SEE ATTACHED DEVIATION

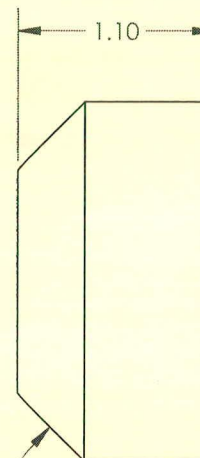
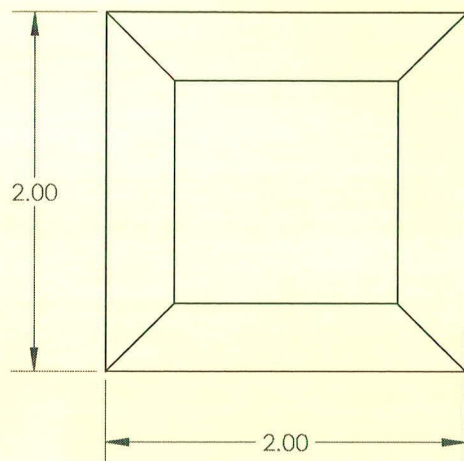
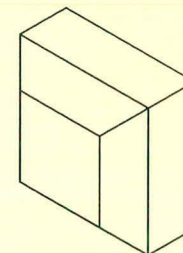
(-9)

ANCHOR POCKET

DART AEROSPACE	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-9	REV 2
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH SEE -1 WELDMENT	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125/
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:2	DATE 12/11/2015 SHEET 7 OF 31

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REV			DESCRIPTION	DATE	INITIAL	APPROVED
REV	ECR					



4X .38 X 45°

SEE ATTACHED DEVIATION

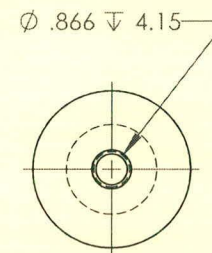
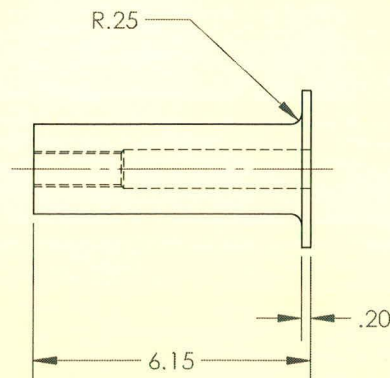
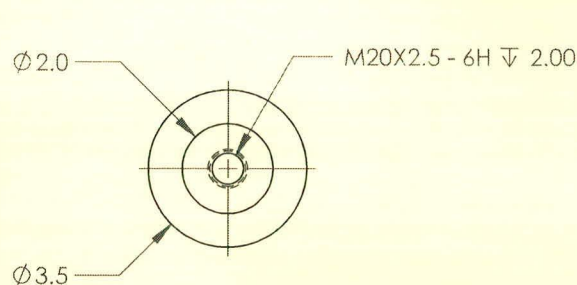
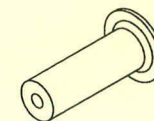
(11)

SQUARE LUG

DART AEROSPACE	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-11	REV 2
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH SEE -1 WELDMENT	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125/√
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:1	DATE 12/11/2015 SHEET 8 OF 31

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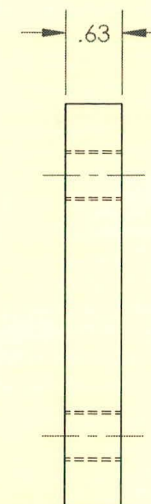
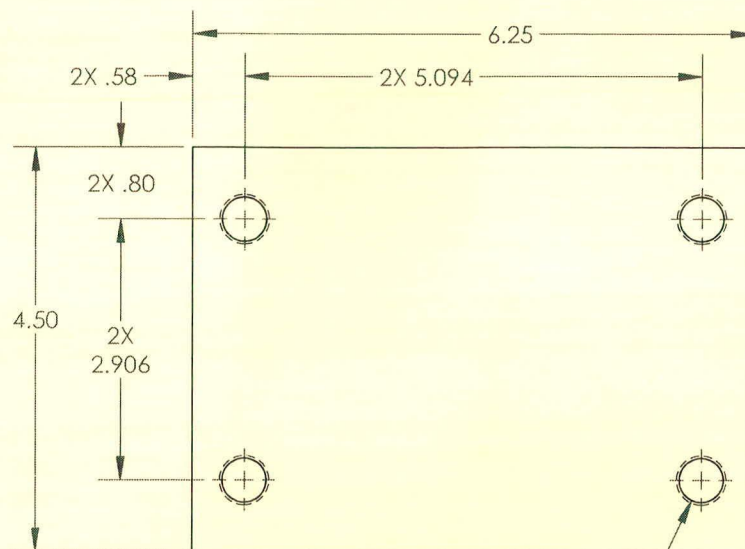
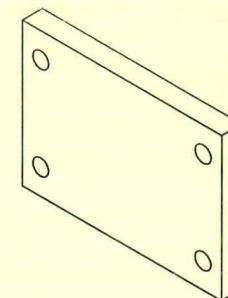
TITLE		TRANSMISSION STAND	
DWG NO.		RBEM632V1005102-13	
REV		2	
MAT'L 4140/4142		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH SEE -1 WELDMENT		.XXX $\pm$.005 FRACTIONS $\pm$ 1/8	
SPEC		.XX $\pm$.01 ANGLES $\pm$ 5°	
		.X $\pm$.1 SURFACES = 125/	
DRAWN BY: DUERFELDT		1. BREAK ALL SHARP EDGES	
CHECKED: CLOUGH		.015 x 45° OR .015R	
OPPS APPR: ANDERSON		2. DIMENSIONAL LIMITS APPLY	
QA APPR: LINDSAY		AFTER PLATING	
APPROVED: GILBERT		3. INTERPRET DIM AND TOL PER	
		ASME Y14.5M-2009	
		USED ON MODEL	
		H175	
SCALE 1:4		DATE 12/11/2015	SHEET 9 OF 31

(13)

JACKSCREW BASE

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REVISIONS			DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION			



4X M14X1.5 - 6H THRU ALL

SEE ATTACHED DEVIATION

(15)

WHEEL PLATE

DART AEROSPACE	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-15	REV 2
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH SEE -1 WELDMENT	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125/
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:2	DATE 12/11/2015 SHEET 10 OF 31

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REV

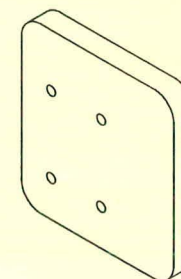
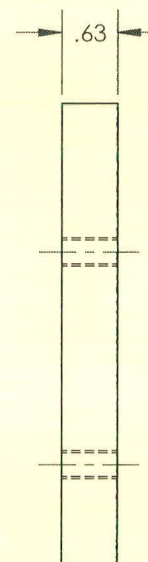
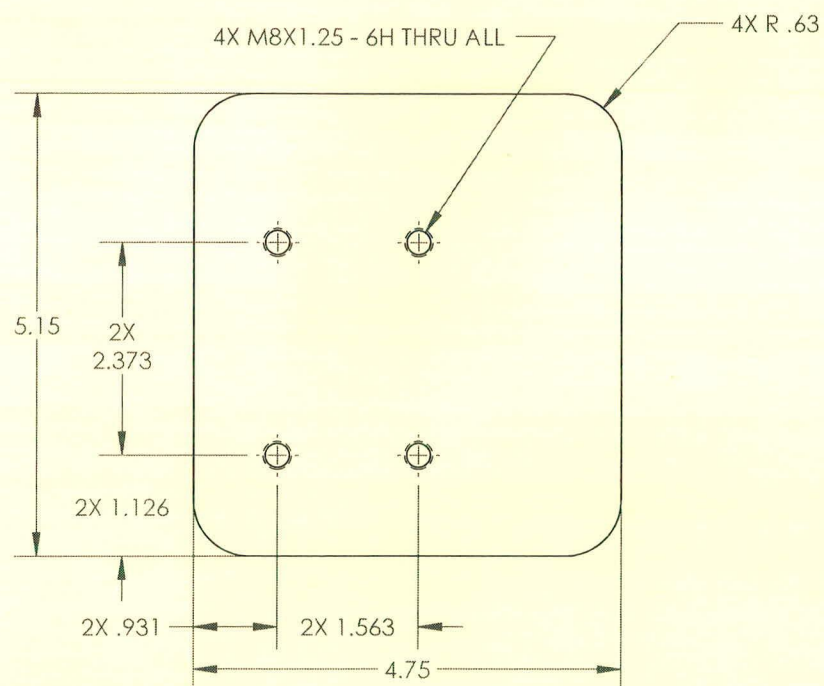
ECR

REVISIONS
DESCRIPTION

DATE

INITIAL

APPROVED



SEE ATTACHED DEVIATION

(-17)

SMALL MOUNT PLATE



TITLE

TRANSMISSION STAND

DWG NO.

RBEM632V1005102-17

REV

2

MAT'L A36/1018/1020 HR

HEAT

TREAT

FINISH

SPEC

DRAWN BY:

DUERFELDT

CHECKED:

CLOUGH

OPPS APPR:

ANDERSON

QA APPR:

LINDSAY

APPROVED:

GILBERT

UNLESS OTHERWISE SPECIFIED

DIMENSIONS ARE IN INCHES

.XXX ± .005 FRACTIONS ± 1/8

.XX ± .01 ANGLES ± 5°

.X ± .1 SURFACES = 125°

1. BREAK ALL SHARP EDGES

.015 x 45° OR .015R

2. DIMENSIONAL LIMITS APPLY

AFTER PLATING

3. INTERPRET DIM AND TOL PER

ASME Y14.5M-2009

USED ON MODEL

H175

SCALE

1:2

DATE

12/11/2015

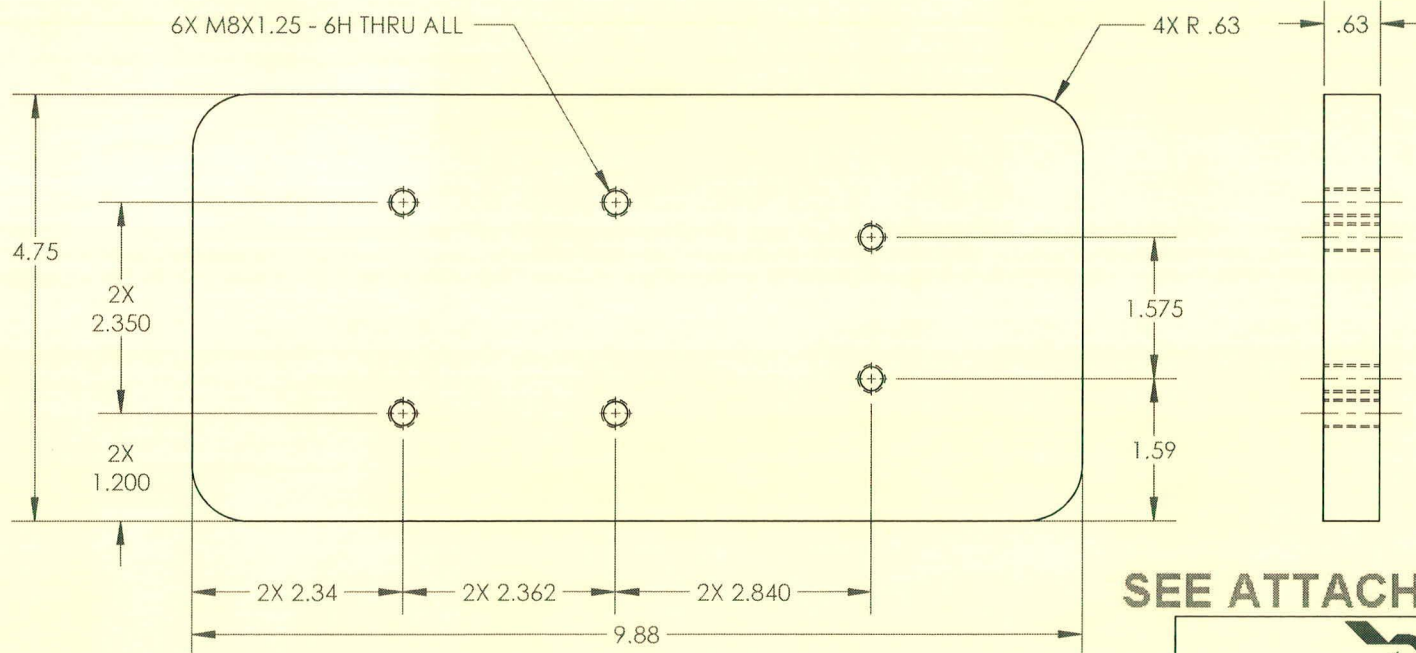
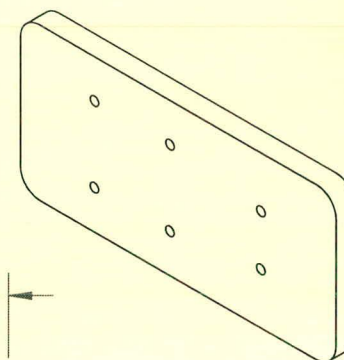
SHEET 11 OF 31

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REV ECR

REVISIONS
DESCRIPTION

DATE INITIAL APPROVED



SEE ATTACHED DEVIATION



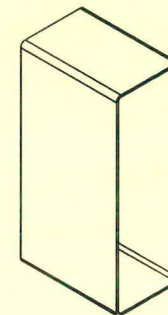
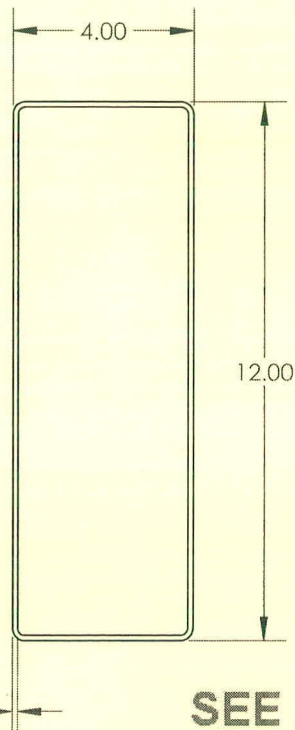
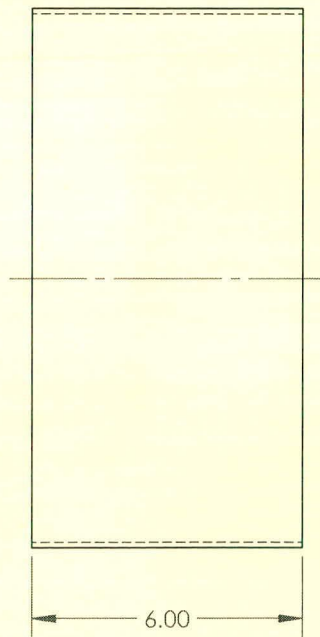
TITLE		TRANSMISSION STAND	
DWG NO.		RBEM632V1005102-19	
REV		2	
MAT'L A36/1018/1020 HR		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH SEE -1 WELDMENT		.XXX ± .005 FRACTIONS ± 1/8	
SPEC		.XX ± .01 ANGLES ± 5°	
		.X ± .1 SURFACES = 125/	
DRAWN BY: DUERFELDT		1. BREAK ALL SHARP EDGES	
CHECKED: CLOUGH		.015 x 45° OR .015R	
OPPS APPR: ANDERSON		2. DIMENSIONAL LIMITS APPLY	
QA APPR: LINDSAY		AFTER PLATING	
APPROVED: GILBERT		3. INTERPRET DIM AND TOL PER	
		ASME Y14.5M-2009	
SCALE 1:2		USED ON MODEL	
DATE 12/11/2015		H175	
		SHEET 12 OF 31	

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LARGE MOUNT PLATE

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REVISIONS						
REV	ECR	DESCRIPTION		DATE	INITIAL	APPROVED
2	16-0182	-21 CH'D DIM WAS .13 IS .12.		10/20/2016	SM	JAG



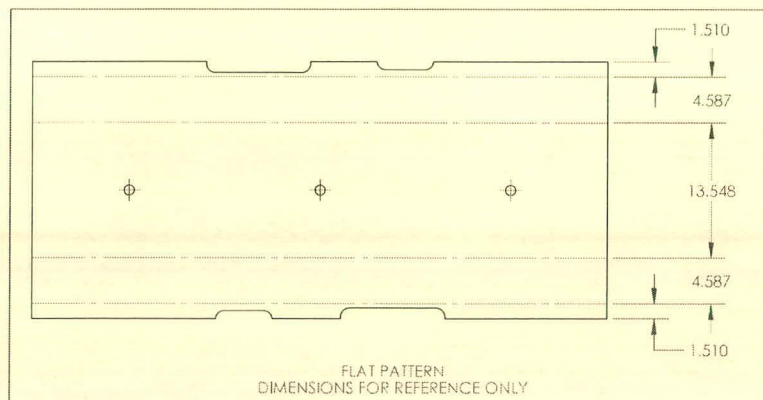
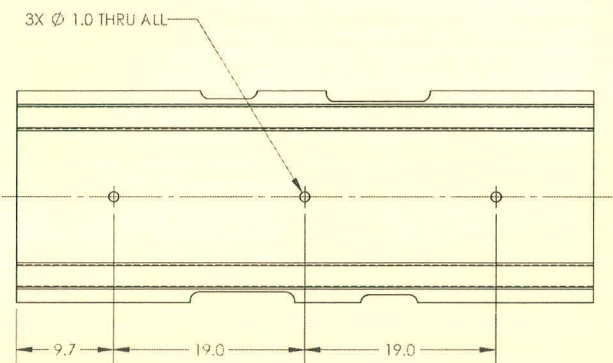
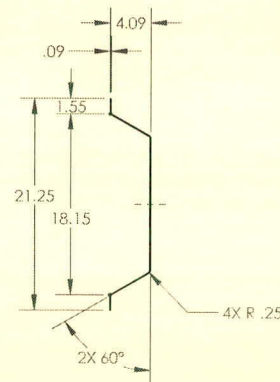
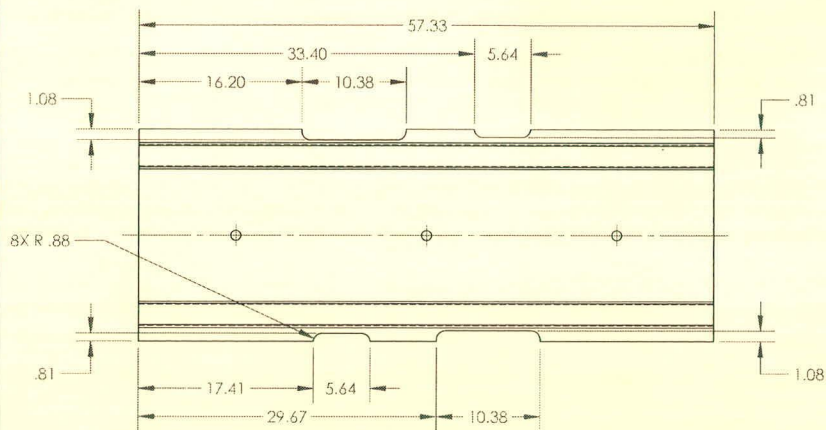
SEE ATTACHED DEVIATION

(-21)
FORK POCKET

DART AEROSPACE	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-21	REV 2
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ±1°
	.X ± .1 SURFACES = 125/
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	H175
SCALE 1:4	DATE 12/11/2015 SHEET 13 OF 31

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				APPROVED



-23

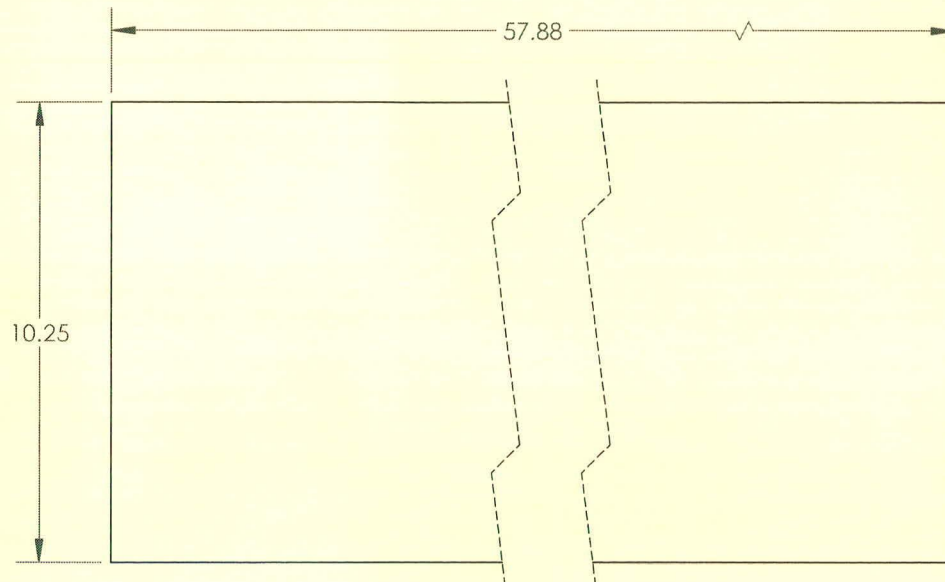
BOTTOM PAN

SEE ATTACHED DEVIATION

DART AEROSPACE	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-23	REV 2
MATERIAL: A36/1018/1020 HR	
FINISH: SEE -1 WELDMENT	
SPEC: UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES ± 125	
1. BREAK ALL SHARP EDGES 2. DIMENSIONAL LIMITS APPLY 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: DUERFELDT	
CHECKED: CLOUGH	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
USED ON MODEL H175	
SCALE 1:12	DATE 12/11/2015
SHEET 14 OF 31	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0182	-25 CH'D DIM WAS .09 IS .11.	10/20/2016	SM	JAG



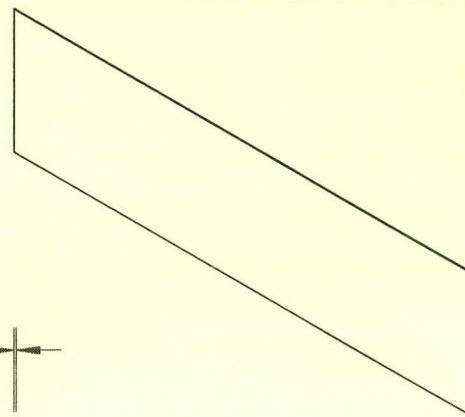
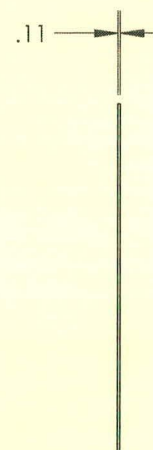
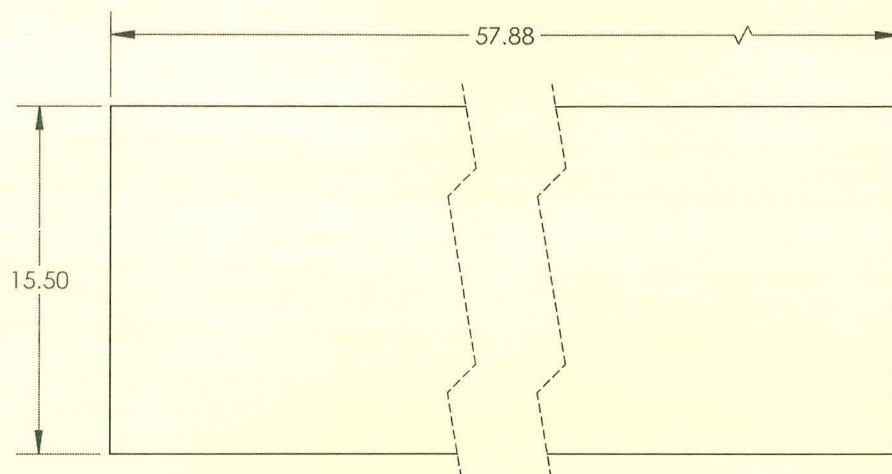
SEE ATTACHED DEVIATION

(-25)
SMALL COVER

DART AEROSPACE	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-25	REV 2
MAT'L A36/1018/1020 HR HEAT TREAT FINISH SEE -1 WELDMENT SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ±1° .X ± .1 SURFACES = 125/✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: DUERFELDT CHECKED: CLOUGH OPFS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
USED ON MODEL H175	
SCALE 1:4	DATE 12/11/2015
SHEET 15 OF 31	

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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
2	16-0182	-27 CH'D DIM WAS .09 IS .11.			10/20/2016	SM JAG



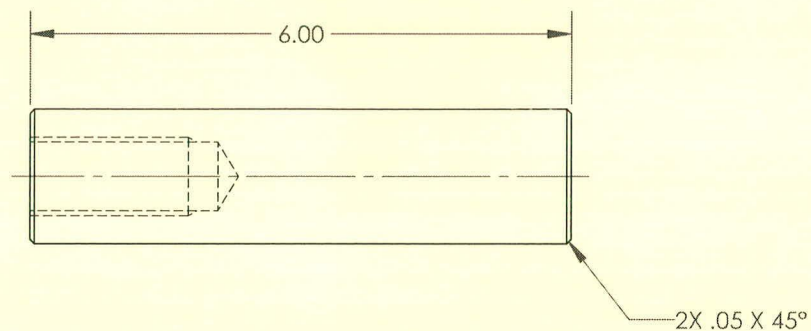
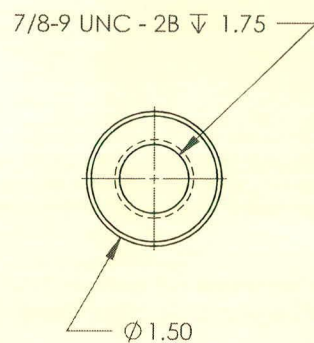
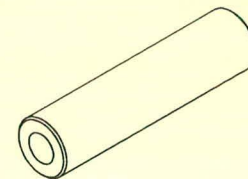
SEE ATTACHED DEVIATION

(-27)
LARGE COVER

DART AEROSPACE	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-27	REV 2
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH SEE -1 WELDMENT	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125/√
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:8	DATE 12/11/2015 SHEET 16 OF 31

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REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED
2	18-0182	-29 CH'D DIM WAS M20X2.5 - 6H ∇ 1.58 IS 7/8-9 UNC - 2B ∇ 1.75			10/21/2016	SM	JAG



SEE ATTACHED DEVIATION

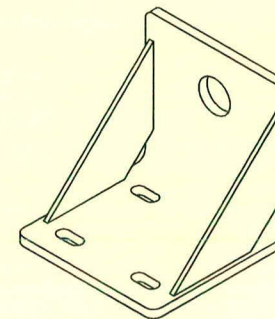
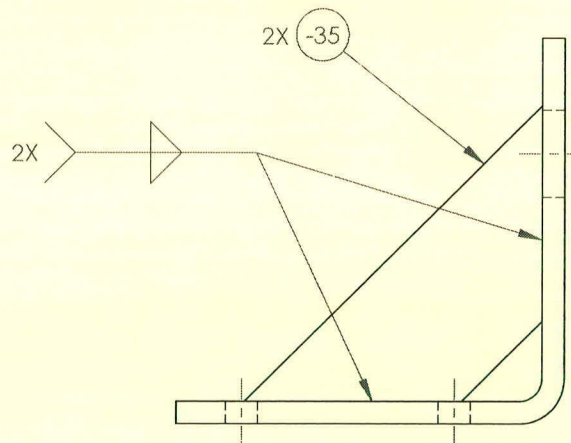
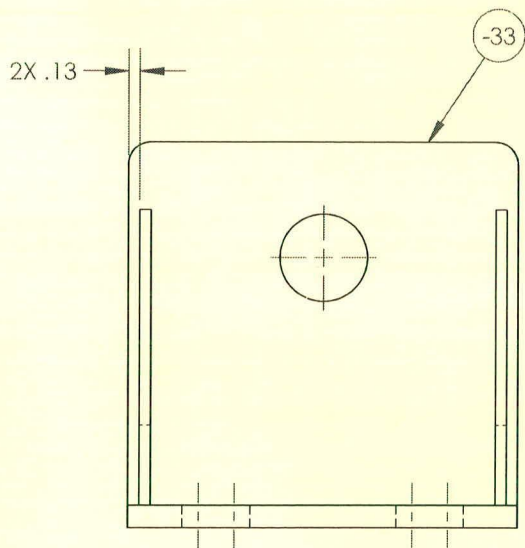
DART AEROSPACE	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-29	REV 2
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX $\pm$.005 FRACTIONS $\pm$ 1/8
FINISH SEE -1 WELDMENT	.XX $\pm$.01 ANGLES $\pm$ 5°
SPEC	X $\pm$.1 SURFACES = 125/
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 X 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:2	DATE 12/11/2015 SHEET 17 OF 31

(-29)

TIE DOWN ANCHOR

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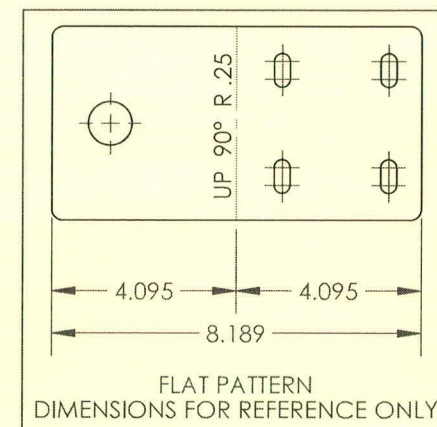
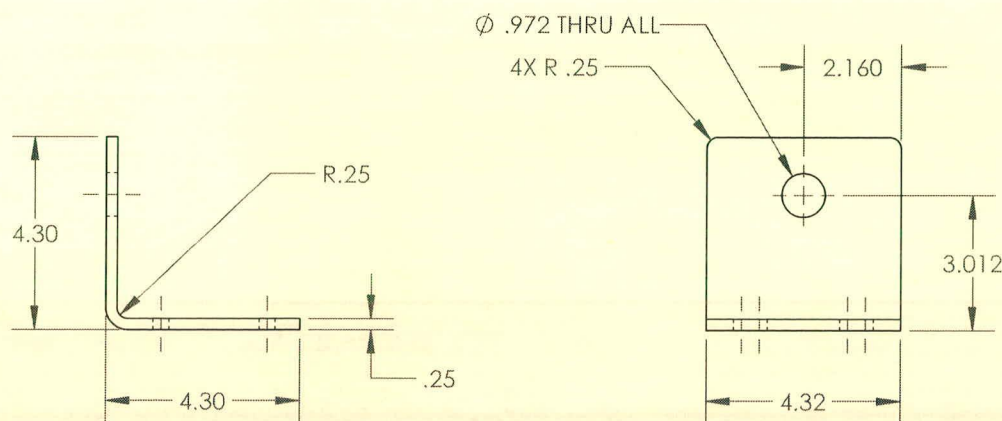
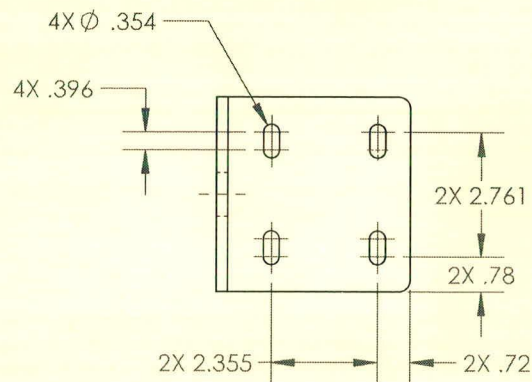
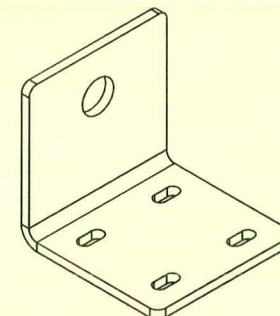
SEE ATTACHED DEVIATION

(-31)
BRACKET WELDMENT

DART AEROSPACE	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-31	REV 2
MAT'L HEAT TREAT FINISH POWDER COAT YELLOW SPEC FED #13538	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125/	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL H175	
DRAWN BY: DUERFELDT CHECKED: CLOUGH OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	SCALE 1:2 DATE 12/11/2015 SHEET 18 OF 31

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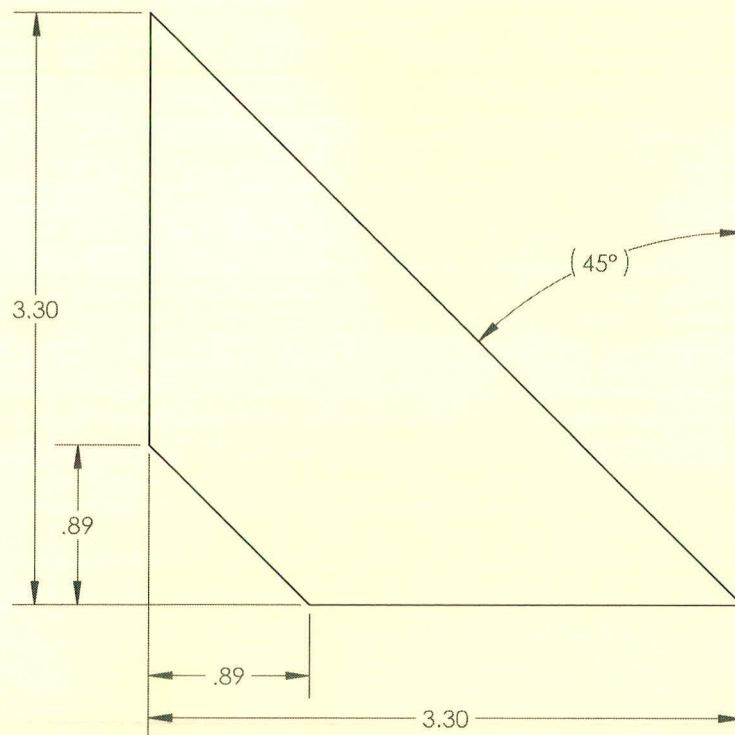
(-33)

BRACKET

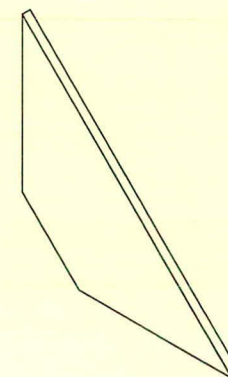
DART AEROSPACE	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-33	REV 2
MATL A36/1018/1020 HR HEAT TREAT FINISH SEE -31 WELDMENT SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125/	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL H175	
DRAWN BY: DUERFELDT CHECKED: CLOUGH OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	SCALE 1:4 DATE 12/11/2015 SHEET 19 OF 31

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.13



SEE ATTACHED DEVIATION

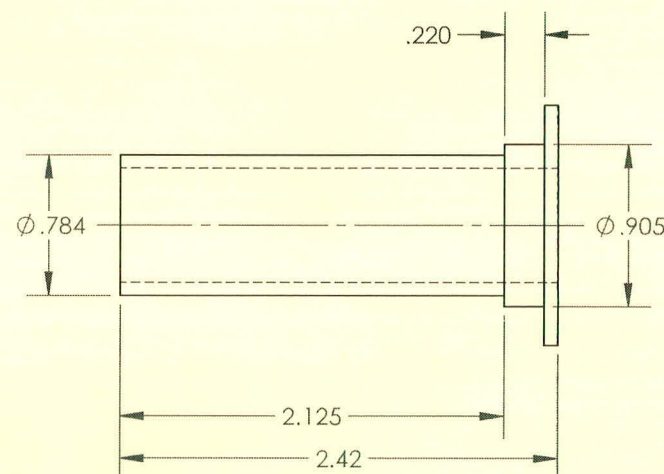
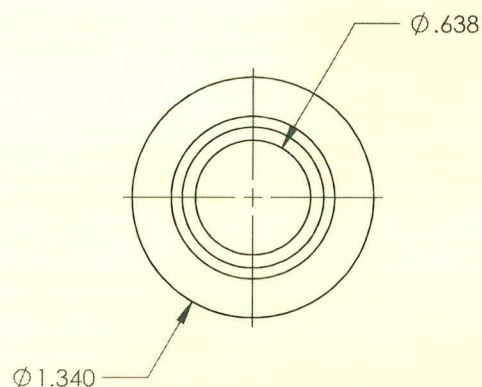
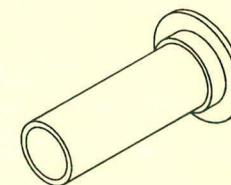
(-35)

BRACKET GUSSET

DART AEROSPACE	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-35	REV 2
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH SEE -31 WELDMENT	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125/
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:1	DATE 12/11/2015 SHEET 20 OF 31

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REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	



SEE ATTACHED DEVIATION



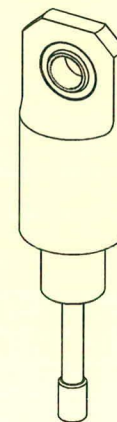
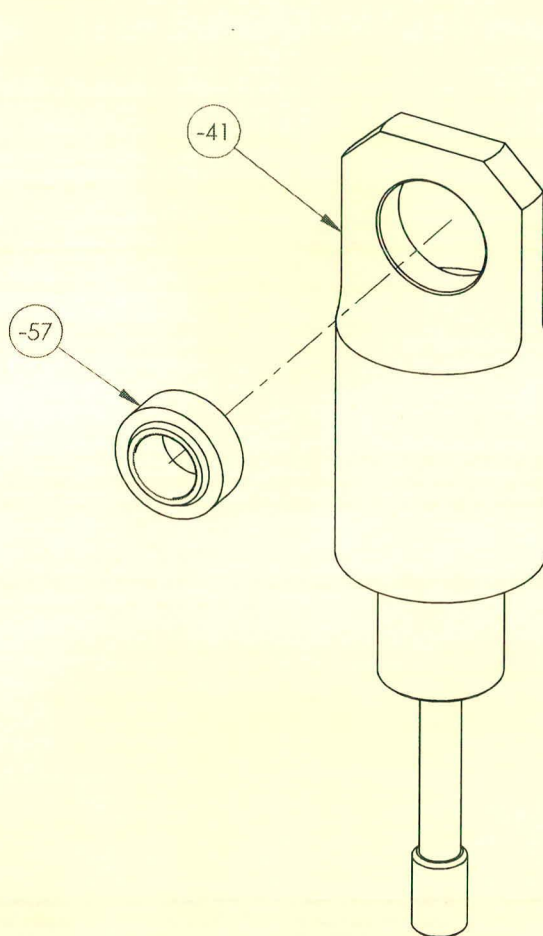
TITLE		TRANSMISSION STAND	
DWG NO.		RBEM632V1005102-37	
REV		2	
MAT'L 4140/4142		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH ZINC PLATE		.XXX ± .005 FRACTIONS ± 1/8	
SPEC ASTM B633 TYPE I SC 2		.XX ± .01 ANGLES ± 5°	
DRAWN BY: DUERFELDT		.X ± .1 SURFACES = 125/	
CHECKED: CLOUGH		1. BREAK ALL SHARP EDGES	
OPPS APPR: ANDERSON		.015 x 45° OR .015R	
QA APPR: LINDSAY		2. DIMENSIONAL LIMITS APPLY	
APPROVED: GILBERT		AFTER PLATING	
SCALE 1:1		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE 12/11/2015		USED ON MODEL	
SHEET 21 OF 31		H175	

(-37)

BUSHING

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REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	



-39

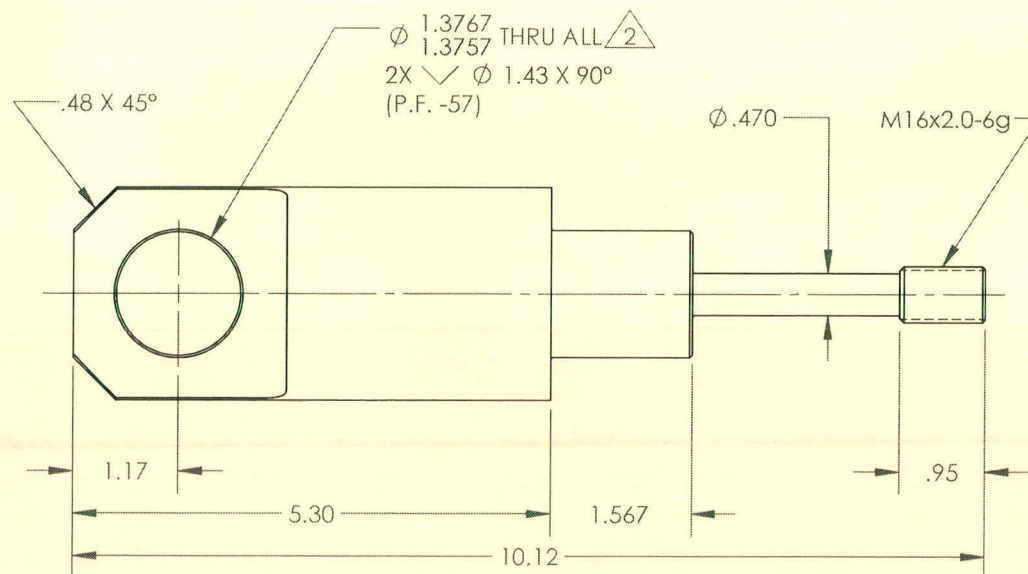
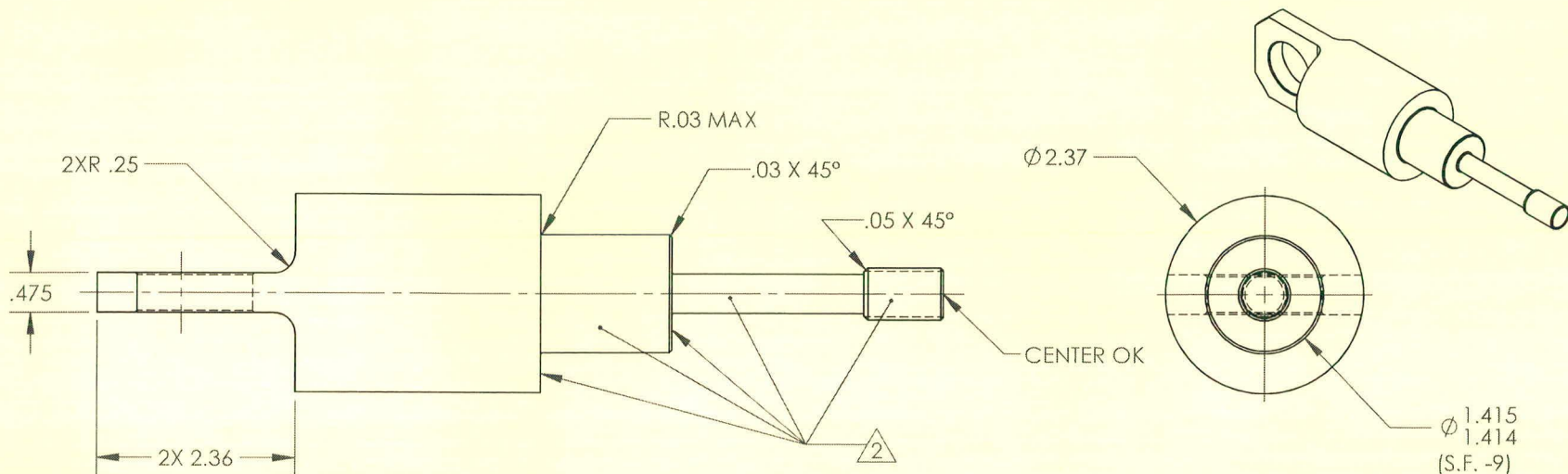
ANCHOR ASSEMBLY

SEE ATTACHED DEVIATION

DART AEROSPACE	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-39	REV 2
MAT'L	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125/
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:2	USED ON MODEL
DATE 12/11/2015	H175
SHEET 22 OF 31	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0182	-41 ADDED DIM .05 X 45°; ADDED NOTE "CENTER OK".	10/20/2016	SM	JAG



(-41)
ANCHOR

SEE ATTACHED DEVIATION

NOTES:

1.-DUAL FINISH:

1ST: ZINC PLATE, ASTM B633 TYPE I SC2

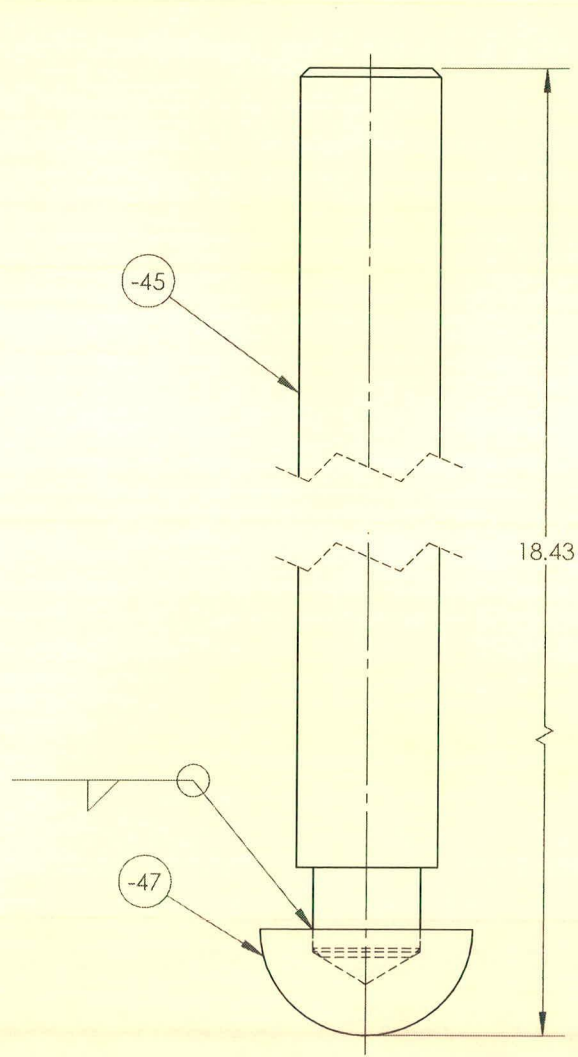
2ND: POWDER COAT YELLOW, FED #13538.

2 NO POWDER COAT THIS SURFACE.

DART AEROSPACE	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-41	REV 2
MAT'L 4140/4142 HEAT TREAT FINISH SEE NOTE 1 SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/√	
1. BREAK ALL SHARP EDGES .015 X 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: DUERFELDT CHECKED: CLOUGH OPFS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	USED ON MODEL H175
SCALE 1:2	DATE 12/11/2015 SHEET 23 OF 31

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED



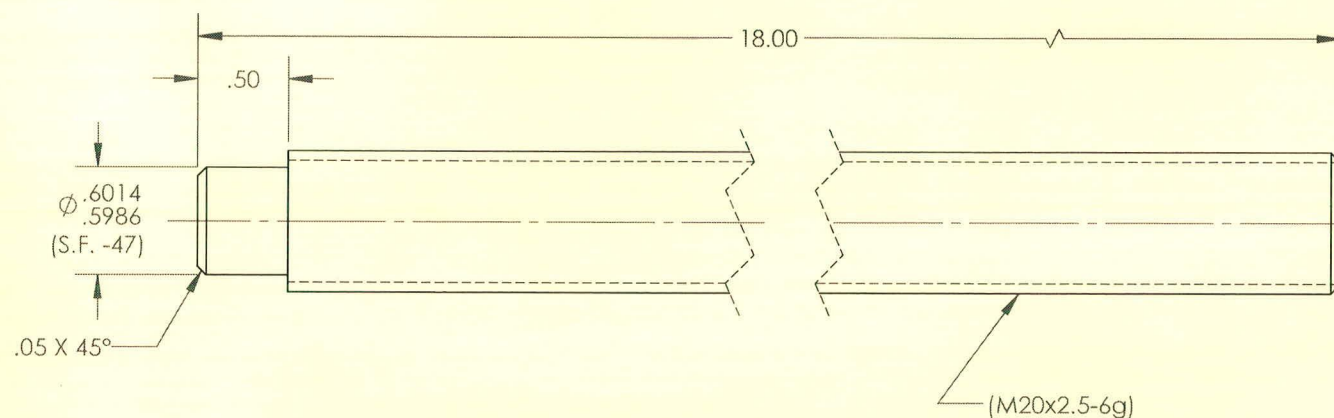
SEE ATTACHED DEVIATION

DART AEROSPACE	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-43	REV 2
MAT'L HEAT TREAT FINISH ZINC PLATE SPEC ASTM B633 TYPE I SC 2	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125/√
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:1	DATE 12/11/2015 SHEET 24 OF 31

JACKSCREW ROD WELDMENT

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REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED
2	16-0182	-45 CH'D DIM WAS Ø.6014/.5986 S.F. -47 IS Ø.6014/.5986 [S.F. -47].			10/20/2016	SM	JAG



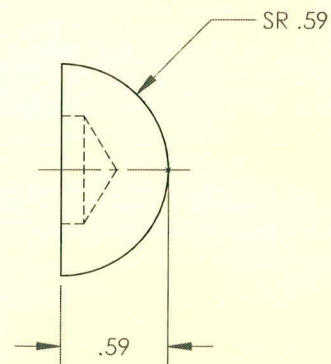
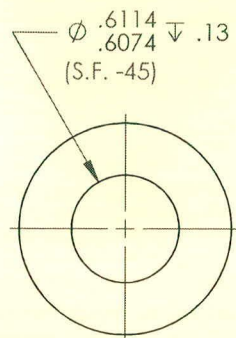
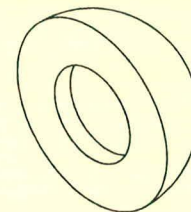
SEE ATTACHED DEVIATION

(-45)
JACKSCREW ROD

DART AEROSPACE	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-45	REV 2
MAT'L B7 HEAT TREAT FINISH SEE -43 WELDMENT SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/√
DRAWN BY: DUERFELDT CHECKED: CLOUGH OPPS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL H175
SCALE 1:1	DATE 12/11/2015 SHEET 25 OF 31

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REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	
2	16-0182	-47 CH'D DIM WAS Ø.6114/.6074 $\sqrt{.13}$ S.F. -45 IS Ø.6114/.6074 $\sqrt{.13}$ (S.F. -45).	10/20/2016	SM	JAG	



SEE ATTACHED DEVIATION

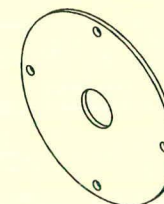
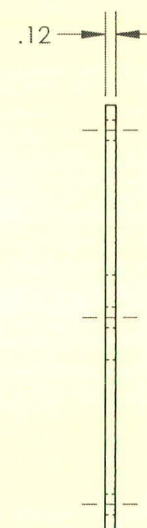
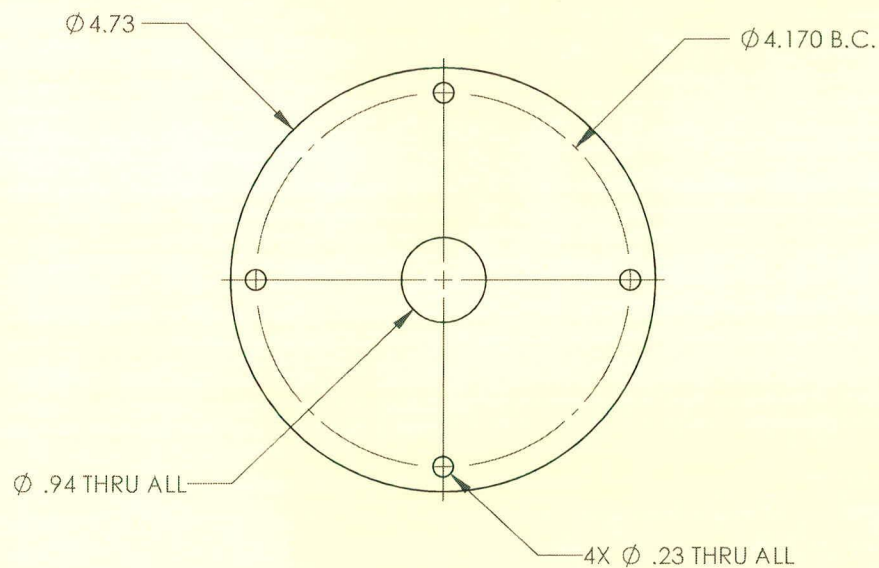
DART AEROSPACE	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-47	REV 2
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH SEE -43 WELDMENT	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125/√
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:1	DATE 12/11/2015 SHEET 26 OF 31

(-47)

JACKSCREW ROD PIVOT

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED



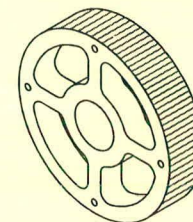
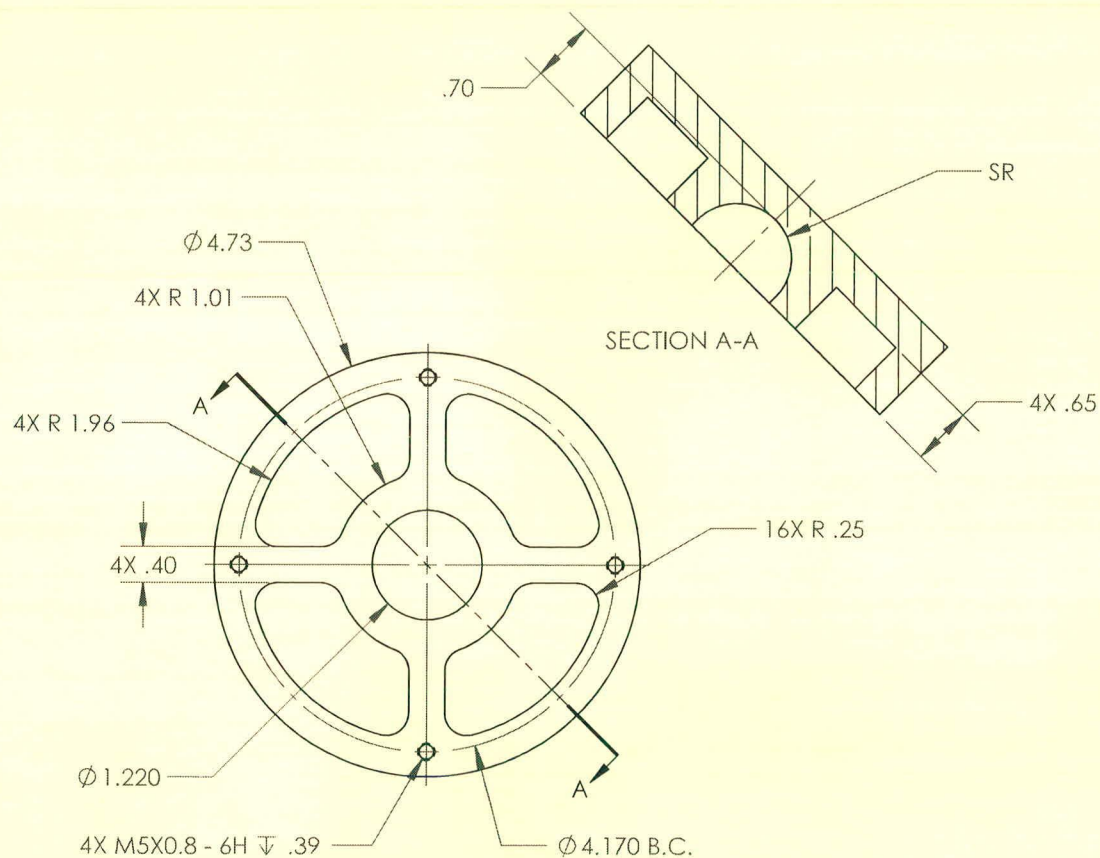
SEE ATTACHED DEVIATION

JACKSCREW COVER

DART AEROSPACE	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-49	REV 2
MATL A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX $\pm$.005 FRACTIONS $\pm$ 1/8
FINISH POWDER COAT YELLOW	.XX $\pm$.01 ANGLES $\pm$ 5°
SPEC FED #13538	.X $\pm$.1 SURFACES = 125/
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:2	DATE 12/11/2015 SHEET 27 OF 31

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REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	



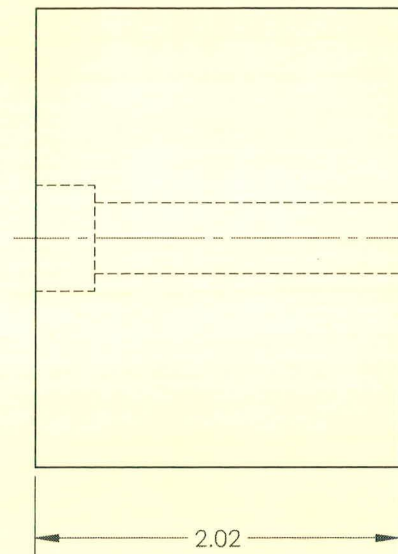
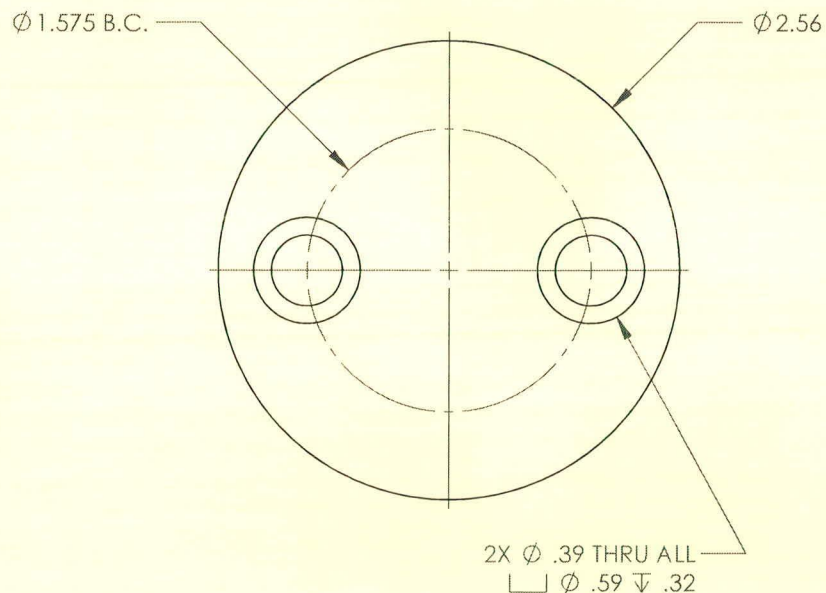
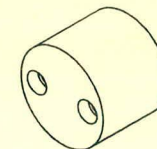
SEE ATTACHED DEVIATION

DART AEROSPACE	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-51	REV 2
MAT'L 4140/4142 HEAT TREAT FINISH POWDER COAT YELLOW SPEC FED #13538	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: DUERFELDT CHECKED: CLOUGH OPFS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
USED ON MODEL H175	
SCALE 1:2	DATE 12/11/2015
SHEET 28 OF 31	

(51)
JACKSCREW FOOT

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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
2	16-0182	-53 CH'D DIM WAS 2X Ø.29 THRU ALL $\square$ Ø.43 ∇ .25 IS 2X Ø.39 THRU ALL $\square$ Ø.59 ∇ .32.		10/20/2016	SM	JAG



SEE ATTACHED DEVIATION

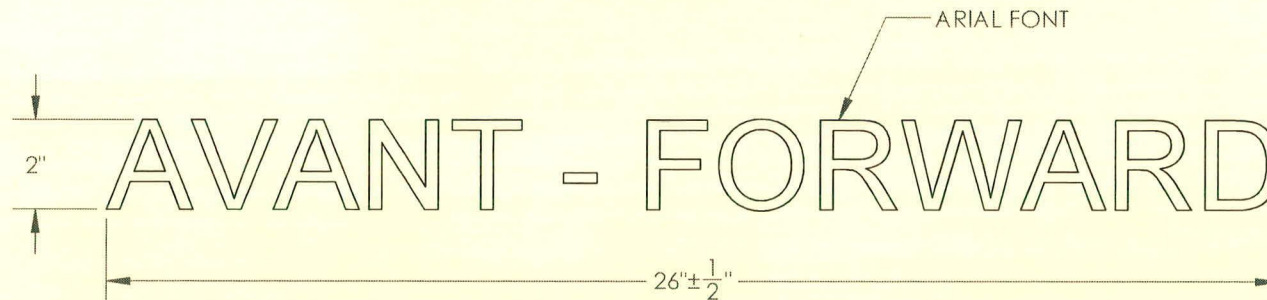
DART AEROSPACE	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-53	REV 2
MAT'L WHITE DELRIN/ACETAL HEAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX $\pm$.005 FRACTIONS $\pm$ 1/8 .XX $\pm$.01 ANGLES $\pm$ 5° .X $\pm$.1 SURFACES = 125/ $\sqrt{}$	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL	
H175	
DRAWN BY: DUERFELDT	
CHECKED: CLOUGH	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:1	DATE 12/11/2015
SHEET 29 OF 31	

(-53)
DELRIN PAD

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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
2	16-0182	-89 ADDED TO BOM QTY 1. ADDED DRAWING.			2/3/2017	SM JAG

AVANT - FORWARD



SEE ATTACHED DEVIATION

(-89)

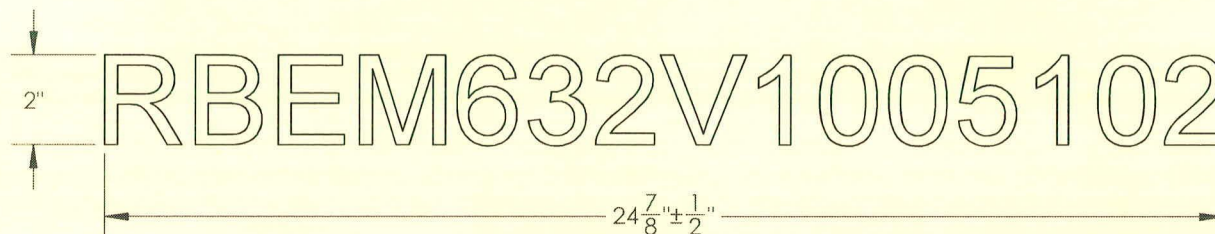
LABEL

DART AEROSPACE	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-89	REV 2
MAT'L BLACK CUT, VINYL HEAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125/✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL	
H175	
SCALE 1:4	DATE 1/18/2017
SHEET 30 OF 31	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0182	-91 ADDED TO BOM QTY 1. ADDED DRAWING.	2/3/2017	SM	JAG

RBEM632V1005102



SEE ATTACHED DEVIATION

(-91)

LABEL

DART AEROSPACE	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-91	REV 2
MAT'L BLACK CUT, VINYL	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125/
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED:	.015 x 45° OR .015R
OPPS APPR:	2. DIMENSIONAL LIMITS APPLY
QA APPR:	AFTER PLATING
APPROVED:	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	H175
SCALE 1:4	DATE 1/18/2017 SHEET 31 OF 31

Entered: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

NCR No. _____

Route update only ☐

Job: _____ Part No. <u>RBEM632V1005102 REV. 2</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QS1042) AUGUST 17, 2018	
Description Work Order Deviation		Disposition		Completed By	
RBEM632V1005102-3 /-5 /-7: - MATERIAL WAS STEEL, IS ASTM A500 REC. TUBING RBEM632V1005102-21: - MATERIAL WAS STEEL, IS ASTM A500 REC. TUBING -WALL THICKNESS WAS .12 IS .19 RBEM632V1005102-25 /-27: - THICKNESS WAS .11 IS 11 GA. (.1196") RBEM632V1005102-23: - THICKNESS WAS .09 IS 13 GA. (.0897") RBEM632V1005102-29 /-37 /-41 /-51: - WAS 4140/4142 IS 4140/4142 (28-32 Rc) RBEM632V1005102-51: - WAS WHITE DELRIN/ACETAL IS WHITE DELRIN/ACETAL ASTM D6100 RBEM632V1005102-89 /-91: - MATERIAL WAS BLACK CUT VINYL IS 3M #180C-12 BLACK ADHESIVE-BACKED VINYL		This deviation is acceptable. The fit, form and function of the part will be as originally intended. PER VM		Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause		FAULT CATEGORY			
Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Presservation ☐ Material ☒ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

